

Work Order ID 70593

Wednesday, July 06, 2011 8:37:45 AM



Page 1

Item ID: D412-630-034

Revision ID:

Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011 Start Qty: 3.00

Required Date: 7/11/2011 Req'd Qty: 3.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

110



Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per dwg D412-630 p.14
Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: 41079.29
COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: 4114596

11-07-21
for BG 11-7-21

11/07/19

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Start Date: 6/10/2011 Start Qty: 3.00

Required Date: 7/11/2011 Req'd Qty: 3.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Memo

0.00

130



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

140



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

11.07.21

11/12/11

11.07.21

11/12/11

11/12/11

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Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011 Start Qty: 3.00



Required Date: 7/11/2011 Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev: 6

160

0.00



QC

QC21 - Final Inspection - Work Order Release

Memo

0.00

Quality Control

Perp, 1

11/7/21

MF
11-01-27

Picklist Print

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Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding



Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:A New Issue 06-11-08 JLM
 IPP rev B cen1019, added D2807-041 EC verified by:DD
 IPP rev :C 11.01.06 added route seq ID DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 Nut		Purchased	No			110	Each	33.0000	2	6		6/11/07/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		33							
					117771	23							
					118091	10							
AN3C21A BOLT		Purchased	No			110	Each	77.0000	2	6		6/11/07/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		77							
					109148	7							
					117366	20							
					117514	50							
AN8C16 Bolt		Purchased	No			110	Each	37.0000	2	6		6/11/07/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST345		37							
					106066	37							

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Work Order ID: 70593

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding



Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2012-107



Clevis

Manufactured No

110 Each

15.0000



1

3

Location

Loc Qty

Loc Code

WA005

15

66811

15

D2803-042



Bracket Assembly

Manufactured No

110 Each

3.0000



1

3

Location

Loc Qty

Loc Code

ST149

3

64093

1

71008

2

D2804-042



Bracket Assembly

Manufactured No

110 Each

1.0000



1

3

Location

Loc Qty

Loc Code

ST149

1

69400

1

D2807-041



Door prop

Manufactured No

110 Each

25.0000



2

6

Location

Loc Qty

Loc Code

ST022

17

60540

2

69671

15

ST023

8

68494

8

Handwritten signature and date 6/27/11

Handwritten signature and date 6/27/11

Handwritten signature and date 6/27/11

Handwritten signature and date 6/27/11

Handwritten signature and date 6/27/11

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Work Order ID: 70593

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2813



Washer

Manufactured No

110 Each

21.0000

2

6



Location

Loc Qty

Loc Code

ST023

21

69386

21

D3395-1



Bushing

Manufactured No

110 Each

60.0000

4

12



Location

Loc Qty

Loc Code

ST052

60

69387

20

70775

40

D3562-042



Step Assembly, RH

MS21043-3



Nut

Manufactured No

110 Each

0.0000

1

3



B 70062



Purchased No

110 Each

1,133.000

4

12



Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1061

112314

69

118077

922

MS24665-302



Cotter Pin

Purchased No

110 Each

184.0000

2

6



Location

Loc Qty

Loc Code

ST357

184

117460

184

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Parent Item: D412-630-034

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Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

MS24693-C280

Purchased

No

110

Each

41.0000

2

6



Screw



GP 11/07/11

64

Location

Loc Qty

Loc Code

ST310

40

115594

10

118093

30

ST318

1

111279

1

NAS1515H3

Purchased

No

110

Each

166.0000

6

18



Washer



GP 11/07/11

Location

Loc Qty

Loc Code

ST277

166

116373

6

117460

60

118078

100

NAS1515H5L

Purchased

No

110

Each

68.0000

4

12



WASHER



GP 11/07/11

128

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

28

111359

28

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Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1515H8



Washer

Purchased

No

110

Each

227.0000

4

12



Handwritten signature

Location

Loc Qty

Loc Code

ST278

227

111275

35

111411

192

Handwritten: 128

AN44C7A



Eyebolt

Purchased

No

130

Each

65.0000

1

3



Handwritten signature

Location

Loc Qty

Loc Code

ST362

65

109013

25

111308

40

Handwritten: 1

AN4C10A



Bolt

Purchased

No

130

Each

73.0000

1

3



Handwritten signature

Location

Loc Qty

Loc Code

ST356

73

112243

43

114523

30

Handwritten: 1

AN4C15A



Bolt

Purchased

No

130

Each

93.0000

2

6



Handwritten signature

Location

Loc Qty

Loc Code

ST358

93

115835

11

117441

32

117795

50

Handwritten: 2

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Parent Item Name: Heli Access Step RH Folding



Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN4C6A
Bolt
x1

Purchased

No

130

Each

410.0000

1

3



sf

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST306	12	
117313	12	
ST356	394	
116704	19	
<u>117619</u>	150	1
117794	50	
117872	75	
118191	100	

AN5C15A
Bolt
x1

Purchased

No

130

Each

65.0000

2

6



sf

Location	Loc Qty	Loc Code
ST338	20	
118191	20	X
ST339	45	
<u>111819</u>	7	1
117764	13	
117885	25	

D2806-1
Bushing
x1

Manufactured

No

130

Each

26.0000

2

6



11/12/11

Location	Loc Qty	Loc Code
ST022	26	
68492	6	2
70885	20	

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Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2806-3



Bushing

Manufactured No

130

Each

27.0000

2



6

Location

Loc Qty

Loc Code

ST022

27

69401

7

70886

20

2

D2810-5



Strut

Manufactured No

130

Each

8.0000

1



3

Location

Loc Qty

Loc Code

ST265

8

52034

1

69402

7

D3396-1



Spacer

Manufactured No

130

Each

38.0000

2



6

Location

Loc Qty

Loc Code

ST052

38

46748

8

69906

30

2

MS21043-4



Nut

Purchased No

130

Each

897.0000

4



12

11/7/12

Location

Loc Qty

Loc Code

EG

40

104603

40

ST301

857

117601

357

117793

500

4

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Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-5

Purchased

No

130

Each

583.0000

3

9

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

463

112314

363

116548

100

ST314

100

118159

100

NAS1515114

Purchased

No

130

Each

180.0000

7

21

Washer

Location

Loc Qty

Loc Code

ST277

180

111525

2

116169

3

117460

50

117735

75

118078

50

NAS1515H5

Purchased

No

130

Each

167.0000

7

21

Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

127

103286

100

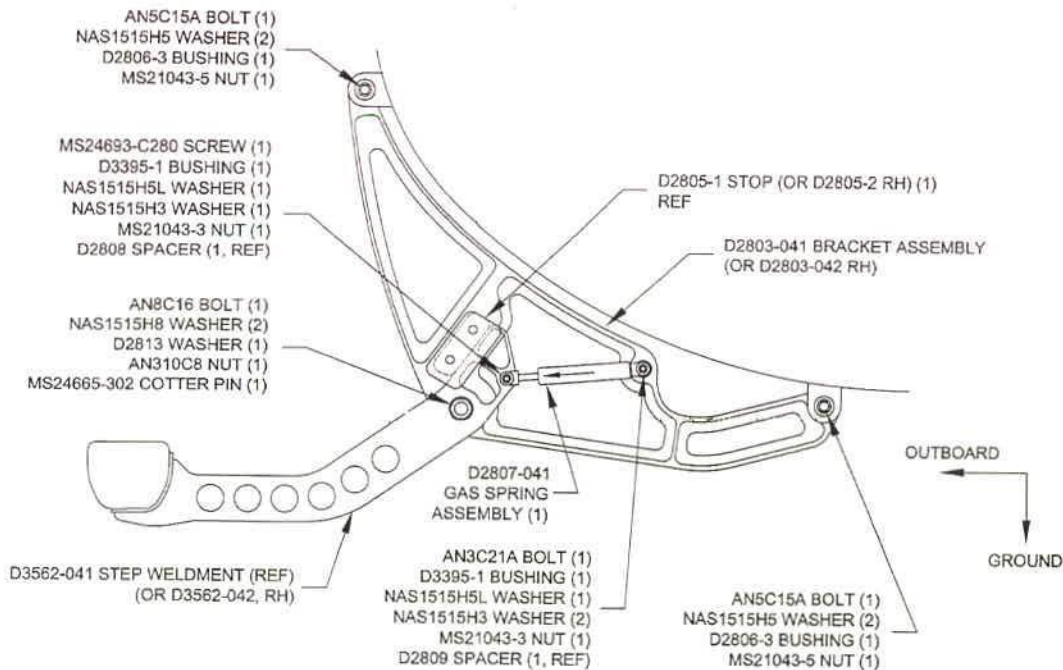
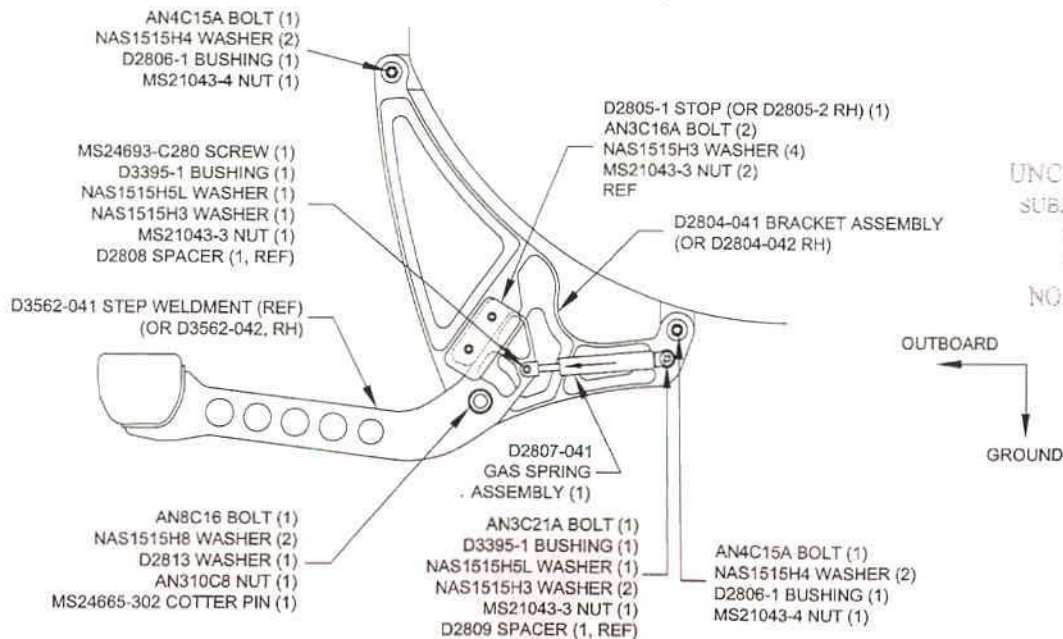
109430

27

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D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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